

Date: Monday, 10/30/2006 4:14:42 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH
Job Number : 29223
Estimate Number : 10274
P.O. Number : *N/A* Part Number : D350591312
This Issue : 10/30/2006 S.O. No. : *N/A* Drawing Number : D3272 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : A
Previous Run : 28928 Material : *N/A*
Written By : *JA* Due Date : 11/30/2006 Qty: 10 Um: Each
Checked & Approved By : *JA 061031*
Comment : Est Rev: A 04.03.22 New issue KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

KJ 061031

2.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: ~

Qty Part Number

Description Batch

1 D2622-120

Extrusion *328215**RE 06-11-15 10*

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

RE 06-11-15 10

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

RE 06-11-16 10

3-Deburr

RE 06-11-16 10

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RE 06-11-16 10

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

RE 06-11-16 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 29223

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3067-1

End Plate

328270

6.0

D32191

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

329235

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

1118838 m19612

3-Grind End Plate flush

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

q.m yl

06/11/23 X 10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

106/11/20 (10)
1106/11/20 (10)
106/11/20 (10)
106/11/20 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 29223

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy 328738

J.E. 06-12-6 10

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer 329609

J.E. 06-12-6 10

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet 1101649

J.E. 06-12-6 10

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

J.E. 06-12-6 10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.E. 06-12-06 (10)

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate 328270

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 29223

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M100237*

4-Grind End Plate flush

P.E. 06. 12. 10
P.E. 06. 12. 7 10
P.E. 06. 12. 7 10
P.E. 06. 12. 7 10

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/06/07 (10)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/06/07 (10)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

M.G. 06/12/08

(10)

22.0

POWDER COATING

POWDER COATING

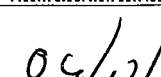


Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M102391

M.B./A.M. 06/12/08



(10X)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

M108005

06/12/19

(10X)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

P.C. 06/12/21 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 29223

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

29646-24 MCR ✓ B29646-16 MCR PC 7/01/05

27.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing

28248- ✓

28.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip

28258- ✓

29.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug

29354-8 MCR ✓

B29357 (16) PC 7/01/05

30.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly

28273- ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 29223

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

M101723 - ✓

32.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A

Bolt

M102630 - ✓

33.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A

Bolt

M102602 - ✓

34.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M10443 - ✓

35.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M102339 - ✓

36.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M100564 - ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *LE* Date: 07/01/08
 QA:-N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

101917 ✓

38.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

111918 ✓

39.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

1102171 ✓

Comile B. 6/12/22 (10)

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PU 6/10/27 (4) 28/01/25 (6)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location: REUB

EB 07/01/05 (10)

27/1/05 (10)

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 07/01/08

Job Completion



W 07.11.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3272	REV. A SHEET 1 OF 2
DATE 04.03.01		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	

RELEASED
04.04.05 *#*

Part No.	Description	QTY -041	QTY -042
D3272-041	Step Assembly, High Long (LH)	X	
D3272-042	Step Assembly, High Long (RH)		X
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE
WORK ORDER
NO. 29223

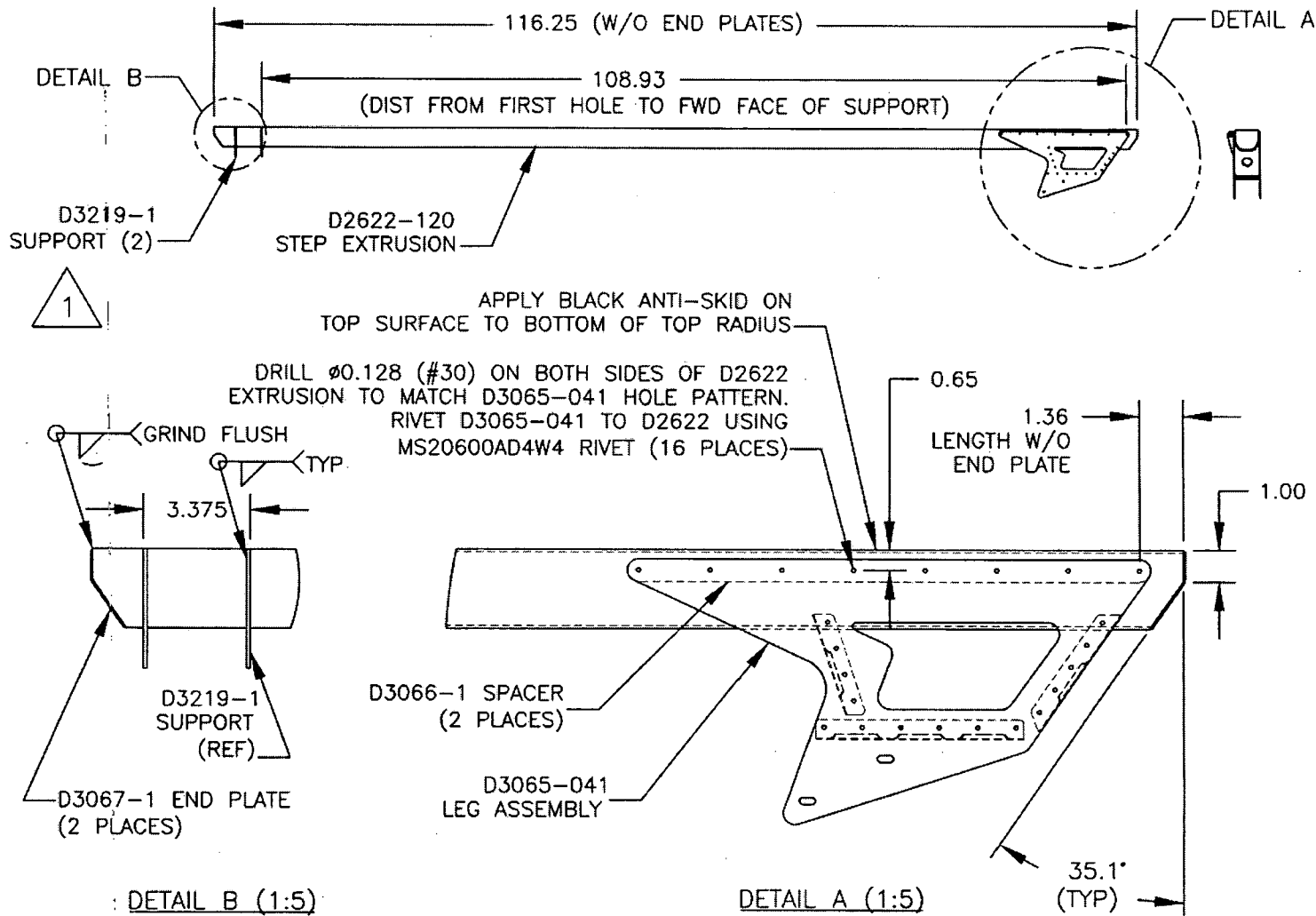
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DART



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD 2 HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	APPROVED	CP	DRAWING NO.	REV. A
				D3272	SHEET 2 OF 2
DATE	04.03.01	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20



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04.04.05

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WORK ORDER
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Wedding

cell

6/13

